£7.			<u> </u>								
Work Ord September-21-				*906	324*		.,				Page
Item ID: Revision ID:	D350-636-	015		Accept	*N900	040	100)* s	Setup Star	rt *N	S1*
Item Name:	Skidtube ST	D w/ Training Wearplates	s, LH						Sto	p *N	S2*
Start Date:	9/21/12	Start Qty: 1.00	*1*	+	Cust Item 1	ID:					
Required Date	e: 10/26/12	Req'd Qty: 1.00	*1*	*	Customer:						
Reference:			-								
Approvals:	Process P	lan: MLブ	Date: 12-09	-Z (Tooling:	D	ate:		R	tun Sta	1/1	R1*
	QC:		Date:	SPC (Y/N):	D	ate:			Sto	*N	R2*
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Re	evision Nbr			:						
D3492	C			<i>,</i> e							
D4168	Α	!									-

100 DC

Document Control

100

IIN-D350-636

DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-015 CHG 004

W MUJ 12-10-15

NCR:	Yes	/	Nο

DQA:

Date:

NCR:	Yes	/ No				WORK ORDER NON-	CON	NFORN	MANCE / UP	PDATE			
		,									QA Closed:	Date	2:
Work Ord	er.		٠			DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
	٠, .					Rework	7		Skid-tube	Crosstube		Water Jet	Engineering
Part I	Vo.					Scrap	1	ſ	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is]	Therm	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR I	Vo.					Work Order Update	_		Large Fab	Composite]	Supplier	
Root					Descri	ption of work order update	\top	nitial	Ad	ction	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
oc/Data													
quip/Tooling						:							
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<i>M</i> aterial			ĺ				1						
etup	<u> </u>		<u> </u>				ļ					i	
Other			*	. A									
rocess	1											ŕ	
upplier		<u> </u>											
raining	L	.											
Inapproved			<u> </u>				1			 			
							FAUL	T CATE	GORY		_		
Landi	ng (7				General	_	1			٦	-	 1
•	L	Bending				Bend	<u> </u>	Grain		L	Ovalized	_	Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	⊢	Temperature/Cure
	L	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	<u>-</u>	Weld
	L	Crushed/	Crimped			Burrs		Instruct	ions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Moved		
		Heat Trea	at ,			Countersink		Mislabe	eled		Positioned V	Vrong _	_
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss/	Surge [Other
		Ripples in	n Bend			Drill Holes		Offset		-			
		Torque W	Vaves in E	xtrusio	n [Drawing		Out of 0	Calibration				
	,	Turning S	equence			Finish	Out of Sequence						
		Wave/Tw	ist in Tul	ne .		Folio		Outside Dimensions					

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September-21-1	2 9:50:31 A	<u>M</u>					- · — — — -				
tem ID: Revision ID:	D350-636-0	015		Accept	*N900	040	1100)* s	Setup Star	*N	S1*
tem Name:	Skidtube ST	D w/ Training Wearplate	es, LH						Stoj	*N	S2*
Start Date:	9/21/12	Start Qty: 1.00	*1	*	Cust Item I	D:					
Required Date:	: 10/26/12	Req'd Qty: 1.00	*1	*	Customer:						
Reference:			•								
Approvals:	Process P	lan:	Date:	Tooling:	D:	ate:		F	Run Star	171	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:			Stop	` *N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		Skidtubes		0.00							
110 Skidtubes		Memo		0.00						· 	
Skidtubes			2600-3 Bent		\	\					
		AFT end p	oer dwg D4168 lot holes for blade fittii	emove bending marks. Scribeing bolt holes using DT8983. O						,	
		4- Locate fitting, sec		tting bolt holes and drill pilot l	noles for blade						÷ .
			vd step holes using DT9 04168, detail A	9616. Ensure proper positionin	g. All holes as	•					
.				4168 sheet 4 (D4168-1 details t side only DT8863B for secon			`	\	. I	1_	
ers Co			DT8863B on second s ND SIDE***	ide of tube and drill pilot holes	s for detail B.) J	\$ 12/0	अ वि	
		8- Drill m	ost FWD wearplate ho	ole using DT9678 locating off	of 66.54" hole.						
				.297" (total of 2 holes per side detail D section H-H to 0.500'							
			ling as per OSI 004	D4168 and QSI 004.Fill groo	ves in bend left	BEIZLO	9/27				
		Du	ù out 7	toe spools							

												DQA:	Da	te:	, :
NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORM	AANCE / UP	DATE		_		•	
											(QA Closed:	Da	te:	•
Work Ord	er:					DISPOSITION				AGAINST DI	EP.	ARTMENT/	PROCESS		
Part I	- No					Scrap Machining Small F Use-as-is Thermoforming Finish Work Order Update Large Fab Compos			Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other	
Root					Descri	ption of work order update	1	nitial	Act	tion		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verificatio	n_	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved															
							AUL	T CATE	GORY						
Landi	ing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread		Unclear		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/	ct ssing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled			
	Ripples in Bend					Drill Holes	Offset								

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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Work Ord				*900	624*							Page 3
Item ID: Revision ID:	D350-636-	015		Accept	*N900	040	100) * §	Setup S		*N:	S1*
Item Name:	Skidtube ST	'D w/ Training Wearplates, LH							1	Stop	*N:	S2*
Start Date:	9/21/12	Start Qty: 1.00	*1*		Cust Item I	D:						
Required Date: Reference:	: 10/26/12	Req'd Qty: 1.00	*1*		Customer:							
Approvals:	Process P	Plan: D	ate:	Tooling:	Da	nte:	_	I		Start	*N	R1*
	QC:		ate:	SPC (Y/N):	Da	ite:				Stop	*N	R2*
Sequence ID/ Work Center I	D	* * *	Rod batch: M/	'	Tool ID BE12/09/27 12/09/27	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
120 *120 *120* QC Quality Control	AV.	QC10- Inspect visual per QSI0 Memo		0.00 AS 16	12/09/27							
i30 *:1 3 0 * QC Quality Control		QC5- Inspect part completene Memo	ss to step on W/O	0.00 PAS 0.00	1 12/19/24	٠.						

											DQA:	Date	
NCR:	Yes	/ No				WORK ORDER NON-	O	NFORM	ANCE / UP	DATE			
											QA Closed:	Date	•
Work Orde	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	. ۷٥٠					Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
					··		AUL	T CATE	GORY				
Landi	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread		Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other			
	Ripples in Bend				İ	Drill Holes	Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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Work Orde				*906	324*				Page 4			
Item ID: Revision ID: Item Name:	D350-636-	015 D w/ Training Wearplates	, LH	Accept	*N900	040	100)* s	etup Star Stop	1.7	S1* S2*	=
Start Date: Required Date: Reference:	9/21/12 10/26/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:						
Approvals:	Process P	lan:	Date:	Tooling: SPC (Y/N):		Date:		R	tun Star Stop	[/]	R1* R2*	
Sequence ID/ Work Center ID 140 *1 10* HandFinish Hand Finishing		Operation Description Chemical Conversion Co	at per QSI005 4.1	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	-	
150		QC3- Inspect Part Finish		0.00				()A @			

0.00

Memo

Quality Control

									DQA:	Date:	
NCR: Ye	s / No				WORK ORDER NON-C	QA Closed:	Date:	•			
Work Order:	:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No	Part No				Rework Skid-tube Crosstube Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite					Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
NCK NO	··				Work Order Opdate		Large Fab	composite ₁		2abbliei	
Root				Descri	ption of work order update	Initial	Ac*	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data						-			,		
Equip/Tooling							·				
Operator							, i				
Material											
Setup											
Other											
Process											

Landing	Gear	General					 _
	Bending	Bend		Grain		Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete ,		Part Incorrect	Weld
	Crushed/Crimped.	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination	Г	Maintenance		Part Moved	_
	Heat Treat	Countersink	Г	Mislabeled		Positioned Wrong	_
	Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset			
	Torque Waves in Extrusion	Drawing		Out of Calibration			
	Turning Sequence 👍	Finish		Out of Sequence	-		
	Wave/Twist in Tube	Folio		Outside Dimensions	•		

FAULT CATEGORY

Supplier Training Unapproved

				_				_	-	_
Ser	oten	nbe	r-2	21	-12	2	9:50:3	31	AN	1

September-21-12	9:50:31 Al	М		90n/4												
Item ID: Revision ID:	D350-636-0	15		Accept	*N900	040	100)* s	etup Star	I VI	S1*					
Item Name:	Skidtube STD	w/ Training Wearpla	ates, LH	_					Stop	' *N	S2*					
Start Date:	9/21/12	Start Qty: 1.00	*1	*	Cust Item I	D:										
Required Date: Reference:	10/26/12	Req'd Qty: 1.00	*1	*	Customer:		-									
Approvals:	Process Pla	an:	Date:	Tooling:	Da	ate:		Н	lun Star	" V	R1*					
	QC:		Date:	SPC (Y/N):		ate:			Stop	` *N	R2*					
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp					
160 Skidtubes		Skidtubes Memo		0.00						— no sig proggene		-				
Skidtubes		(total of	up holes of Detail C and 8 holes per side) wg D4168.	d ground handling section AL-Al	L to 0.625"											
		•	up holes of Detail B to 0 wg D4168.	0.750" (total of 4 holes per side)												
		3- Open	float hole to 0.500" (4 p	er side) section AJ-AJ												
		-		per dwg (4 holes per sides) , secti												
• "				ground handling section AL-AL welding instructions on sheet 8)	and float holes			-	1	1						
		5-Debur	r and blow out all chips	from inside of tube				()	512/1	0/01						
		6- Prepa	re tube for welding, rem	ove alodine as required.			/		•	•						
		7-Bond A/R	web D2739 in place as p Sikaflex-291 batch:_	per QSI 015 127 4/3 exp. date: 13/1/19	4	/						,				
		& QSI00 (welding A/R AI		M122399 C	8 and D4170-1											

QA Closed: Date:	A *
DISCOSITION ACAINST DEPARTMENT (DECCESS	
Nork Order: DISPOSITION AGAINST DEPARTMENT/PROCESS	
Part No. Scrap Scrap Machining Small Fab Prod. Eng. Coor. Use-as-is NCR No. Work Order Update Large Fab Composite Supplier	ngineering Quality Other
Root Description of work order update Initial Action Sign &	
	QC Inspector
oc/Data	
quip/Tooling	
perator	
Naterial Naterial	
etup	
ther	
rocess	
upplier	
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inapproved	
FAULT CATEGORY	
Landing Gear General	
	essure/Forced
	mperature/Cure
Cracks Broken/Damaged Inspection Incomplete Part Incorrect We	·
	rong Stock Pulled
Cuffs Contamination Maintenance Part Moved	Ŭ
Heat Treat Countersink Mislabeled Positioned Wrong	·
Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Oth	her
Ripples in Bend Drill Holes Offset	
Torque Waves in Extrusion Drawing Out of Calibration	
Turning Sequence Finish Out of Sequence	
Wave/Twist in Tube Folio Outside Dimensions	

DQA:

Date:

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Work Orde September-21-12				*906				·	Page 6	;			
Item ID: Revision ID: Item Name:	D350-636-(015 D w/ Training Wearplates	, LH	Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*	
Start Date: Required Date:	9/21/12 10/26/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:							
Reference:	• 						-		Run	Start	₽ N II		
Approvals:	Process Plan: QC:			Tooling: SPC (Y/N):	Date:					Stop	*N	R1**	
Sequence ID/ Work Center, II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Pian Code	Accept Qty	t Reje Qty		Reject Number	Insp. Stamp	_
	٠.	11-Spot face dwg D4168,	section AL-AL ection CG-CG	section (total of 4 places por $\sqrt{2-100}$	-11) D3	12/10	/69			P.		= >

******* FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING HOLE IN TUBE ************

QC10- Inspect visual per QSI004- ground welds

170

Memo

Quality Control

												DQA:	Date:	4
NCR:	'es	/ No					WORK ORDER NON-C	ON	IFORM	MANCE / UPD	ATE			
												QA Closed:	Date:	•
Nork Orde	ır.						DISPOSITION	Î			AGAINST DE	PARTMENT/	PROCESS	
WOIK OIGE	٠, .					١	Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.					ı	Scrap			Machining	Small Fab	Prod	d. Eng. Coor.	Quality
	•						Use-as-is		Therm	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR I	10.						Work Order Update			Large Fab	Composite]	Supplier	
Root					Desc	rip	tion of work order update	odate Initial Action			on	Sign &		
Cause		Date	Step	Qty		-	r Non-conformance		ief Eng	Descri	ption	Date	Verification	QC Inspector
oc/Data														
quip/Tooling														
perator									1	,				
Material														
etup	_													
ther														
rocess										-				
upplier														
raining														
Inapproved								<u> </u>	T CATE	COPY				
Landi	nø (General	401	ICAIL	GOKT				
		Bending			Γ	_	Bend		Grain			Ovalized		Pressure/Forced
		Centre No	t Concer	ntric to (o/s		BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks			Ī	_	Broken/Damaged		Inspect	on Incomplete		Part Incorred		Weld
		Crushed/C	Crimped.		ſ		Burrs		Instruct	ions Incomplete/U	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs Contamination								Mainte	enance		Part Moved	<u> </u>	
		Heat Trea	t		ſ		Countersink		Mislabe	eled		Positioned V	Vrong	
,		Inspection	n Strip in	Tube	Ī		Cut Too Short		Misread	d .		Power Loss/	Surge	Other
		Ripples in	Bend				Drill Holes		Offset					
		Torque W	aves in E	xtrusio	۱ [Drawing	Out of Calibration						
		Turning Se	equence				Finish		Out of 9	Sequence	8 ³ :			
		Wave/Twi	ist in Tub	e			Folio		Outside	Dimensions				

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NCR: Y	es / No				WORK ORDER NON-O	CONFOR	MANCE / UF	PDATE			•
	·						·		QA Closed:	Date:	•
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT,	PROCESS	
					Rework]	Skid-tube	Crosstube		Water Jet	Engineering
Part N	0				Scrap		Machining	Small Fab		d. Eng. Coor.	Quality
NCR N	0				Use-as-is Work Order Update	Ther	moforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initial	A	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	g Des	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator				•							
Material	_					12.0	,			i	
Setup	_					2.0					
Other	_				•						
Process											
Supplier	_										
Training	-										
Unapproved	1	l				AULT CAT	ECORY.				
Landin	g Gear				General	AULI CAT	EGONT				
Landin	Bending				Bend	Grain			Ovalized		Pressure/Forced
}	Centre No	nt Conce	ntric to (7/5	BOM/Route	Hardw	zaro	<u> </u>	Over/Under	tolerance	Temperature/Cure
+	Cracks	or conce	THE TO C),3 -	Broken/Damaged	\vdash	tion Incomplete	<u> </u>	Part Incorre		Weld
}	Crushed/	Crimned		\vdash	Burrs	· ·	ctions Incomplete	/Unclear	Part Lost/M		Wrong Stock Pulled
-	Cuffs	ermpeu.	•	<u> </u>	Contamination	-	enance		Part Moved		J ong stock i anca
}	Heat Trea	at			Countersink	Mislat			Positioned \	Vrong	
`\	Inspectio		Tube	-	Cut Too Short	Misrea		<u> </u>	Power Loss/	_	Other
<u> </u>	Ripples in				Drill Holes	Offset		L	اردون در ا		1
				Drawing	\vdash	Calibration			·······		
 	Turning S				Finish	\vdash	Sanuanca	•			

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

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Work Orde September-21-12				*906				Page 8				
Item ID: Revision ID: Item Name:	D350-636-0	D w/ Training Wearplates,	I H	Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*
Start Date: Required Date: Reference:	9/21/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:						IV.	
Approvals:	Process Pl	an:	Date:	Tooling:	D	ate:	-		Run	Start	*N	R1*
	QC:	; -	Date:	SPC (Y/N):	D:	ate:				Stop	*N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
210		QC3- Inspect Part Finish		0.00								, ,
210 QC Quality Control		Memo Inspect for fo	reign object per QSI 024	0.00				_ _ H	8		Ø	12/10/10
220	•			0.00								•

0.00

HandFinishing

Memo

1- Install inserts as per Dwg D4168

220
HandFinish

Hand Finishing



NCR:	(Yes)/	No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: July Date:	•		
12/10/22		•	
Closed: / Date:			

					·				QA Closed:	Date:	
Work Order:	90	062	4		DISPOSITION			AGAINST DE	PARTMENT	PROCESS	
				-015	Rework		Skid-tube X Machining	Crosstube Small Fab	Dro	Water Jet d. Eng Coor.	Engineering Quality
Part No			70-	015	Scrap		~ 	—			Other
NCD No.	17	102	$\langle \langle \rangle$		Use-as-is Work Order Update	l in	ermoforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	- Other
INCK INO	1/	101	<i>/</i> <u>J</u>		work order obdate 7		Large Fau	Composite[Supplie!	
Root				Descrit	otion of work order update	Initia	ıl Act	ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E		iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling		·			at soscoubly that	OAS 16		oh as puz	D.	DAS	
Operator				the cru	s bull spowers were	8-8		efull not bo	2-10-11	17/10/16/10	16
Material	-		14	Wot ca	intercherge for the bushi	0520	242 Domose the P/	<u>L </u>	1	7 1 100	3 -5°
Setup	12/10/10	*	'	for the	uean plate		touch up hels	, with Aloosic		000	Q\$2042
Other 1	1/1/	1800		(Searin	uean plate CS-CS while \$4).	12/10/11	As Per 052005			-1/1/1/t	17/10/11
Supplier	+	760			*	101	175000 413 1/C		•		
Training	1	"	·				invon Paint		<u> </u>		
Unapproved	† .						ADD WHE of to very live the	inspection step	WISION	DAS	
	<u> </u>				F.A	AULT CA	ATEGORY Coupe le		()=- 10	5 10 10 16	u
Landing	Gear				General						.*
	Bending				Bend	Gra	in		Ovalized		Pressure/Forced
	Centre No	ot Concer	ntric to	o/s 🗌	BOM/Route	Hard	dware		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Insp	ection Incomplete	V	Part Incorre	ct	Weld
	Crushed/0	Crimped.			Burrs	Inst	ructions Incomplete/L	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	Mai	intenance		Part Moved		
	Heat Trea	t			Countersink	Misl	labeled		Positioned V		
	Inspection	n Strip in	Tube		Cut Too Short	Misi	read		Power Loss/	Surge	Other
	Ripples in	Bend			Drill Holes	Offs	set		operation u		us at step#166-12
	Torque W	aves in E	xtrusio	n _	Drawing	Out	of Calibration		+ Missoo		γ΄,
	Turning S	equence			Finish	Out	of Sequence				
	Wave/Tw	ist in Tub	oe		Folio	Out	side Dimensions				

* September-21-12 9:50:31 AM

September-21-12	9.30.31 AIN	···											
Revision ID:	D350-636-01	w/ Training Wearplates	s. LH	*N90004010							Start Stop	*N.	S1*
Ã.	9/21/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*			Cust Item I Customer:	D:						
Approvals:	Process Pla	ın:		Toolin	ıg:	D:	ate:			Run	Start	*N	R1*
部で ・					Y/N):	Da	ate:				Stop	*N	R2*
Sequence ID/ Work Center II)	Operation Description			Up/ n Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re	•	Reject Number	Insp. Stamp
730 HandFinish Hand Finishing		2-Spray insi 3-Install bla per dwg D4 SIKA FLEX BATCH: EXP DATE 4-assemble A/R 55-o'ri	₹ 241	D3492 and a	pround handling hard				<u>1</u> LH	×	<u>``</u>		12/10/11
240 *240* QC Quality Control		QC5- Inspect part comp Memo	leteness to step on W/O	0.00	SmB 12.10.11				.1_				

											DQA	\:D	ate: ˌ	
NCR:	Yes	/ No			•	WORK ORDER NON-O	COI	NFORN	MANCE / UP	DATE	QA Closed	d: D	ate:	•
				······································		DISPOSITION				AGAINST D		···		· · · · · · · · · · · · · · · · · · ·
Work Ord Part I NCR I	No.					Scrap Machining Small Fab. Use-as-is Thermoforming Finishing				Crosstube Small Fab Finishing Composite		Water Je od. Eng. Coor ore/Packagin Supplie		Engineering Quality Other
Root					Descri	ption of work order update		Initial	Act	tion	Sign &		*	
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verificati	on	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
		· · · · · · · · · · · · · · · · · · ·					AUL	T CATE	GORY					
Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat)/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink		Instruct Mainte Mislabe	on Incomplete ions Incomplete/ nance led	Unclear	Part Incord Part Lost/l Part Move Positioned	Missing d Wrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
Inspection Strip in Tube Cut Too Short							Misread Power Loss/Surge Other					Other		

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde September-21-12				*906				Page 1			
Revision ID:	D350-636-0 Skidtube STD	15 w/ Training Wearplates	, LH	Accept	*N900	040	100)*	Setup	Start Stop	*NS1* *NS2*
	9/21/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item l	ID:					14(1)
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 250)	Operation Description Pick Kit		Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qt	-	Reject Insp. Number Stamp
250 Packaging Packaging			4A 2A	0.00					<u> </u>	¥frofsc	
²⁶⁰ *2らい*		QC4- 100% Inspect kits	for completeness	0.00 QAS	Mule						
QC Quality Control		Memo	re antiseize is on AN8C2	0.00	•						

270

270
Packaging

Packaging

Memo

0.00

0.00

Packaging

Identify and pack for shipping as per PPPD350-636-015
Location: 12
PPP rev: 1

NCR: Y	'es / No				WORK ORDER NON-C	CONI	FORM	MANCE / UP	DATE			3
								• 		QA Closed:	Date:	*
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT,		
Part N					Rework Scrap Use-as-is Work Order Update		I Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	- †	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Ini	itial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chie	f Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator]			ŀ				<u>'</u>		
Material												
Setup												
Other	_											
Process												
Supplier												
Training												
Unapproved			l i			ALLT	CATE	L GORY		<u> </u>		
Landi	ng Gear				General	AULI	CATE	GORT				
Landin	Bending				Bend	$\Box c$	rain .			Ovalized	Г	Pressure/Forced
	Centre No	ot Conce	ntric to C)/5	BOM/Route		lardwa	ire	<u> </u>	Over/Under	tolerance	Temperature/Cure
	Cracks			"	Broken/Damaged	\vdash		ion Incomplete	<u> </u>	Part Incorre	⊢	Weld
	_	Crimped			Burrs	\vdash		ions Incomplete/	/Unclear	Part Lost/M	<u> </u>	Wrong Stock Pulled
	Crushed/Crimped. Cuffs				Contamination	-		enance		Part Moved		
	Heat Treat				Countersink	\vdash	∕iislabe			Positioned V	Vrong	
	<u> </u>			Cut Too Short	$\boldsymbol{\vdash}$	/lisreac			Power Loss/		Other	
;	F-4			Drill Holes		Offset			.			
	Torque W	laves in E	Extrusion		Drawing		Out of (Calibration		***************************************		
	Torque Waves in Extrusion Turning Sequence				Finish		Out of S	Sequence				***************************************

Outside Dimensions

DQA:

Date: ____

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde September-21-12				*906	324*							Page 11
Item ID: Revision ID: Item Name:	D350-636-6	015 D w/ Training Wearplates	. LH	Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*
Start Date: Required Date: Reference:	9/21/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					ı u	
Approvals:	Process P	lan:	Date:	Tooling: SPC (Y/N):		nte:			Run	Start Stop		R1* R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
280 *280* QC		QC21- Final Inspection -	Work Order Release	0.00					12	-/10	119	4

Quality Control

M12-10-18

									DQA:	Date:	*
NCR: Yes	/ No				WORK ORDER NON-	CONFORM	MANCE / UP	DATE	QA Closed:	Date:	• .
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Work Order.					Rework]	Skid-tube	Crosstube]	Water Jet 🗌	Engineering
Part No.					Scrap	-	Machining	Small Fab	4	d. Eng. Coor.	Quality
NCR No.					Use-as-is Work Order Update	-∤ £	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descr	iption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspecto
Doc/Data Equip/Tooling											
Operator Material											_
Setup										ı.	
Other	l										
Process											
Supplier											

Landing (Gear	General		_	 _
	Bending	Bend	Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped.	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination	Maintenance	Part Moved	
	Heat Treat	Countersink	Mislabeled	Positioned Wrong	
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes	Offset		
	Torque Waves in Extrusion	Drawing	Out of Calibration		
	Turning Sequence	Finish	Out of Sequence		·

Outside Dimensions

FAULT CATEGORY

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

Training Unapproved

- Picklist Print

September-21-12 9:50:28 AM

Work Order ID:

90624

Parent Item:

D350-636-015

DD verf:EC

Parent Item Name:

Skidtube STD w/ Training Wearplates, LH

Start Date: 9/21/12

Required Date: 10/26/12

Page 1

Start Qty: 1.00

Required Qty: 1.00

Gomments:

IPP rev:A 10.09.28 new issue DD verf:EC

IPP Rev:B 11.04.14 ecn11-553 IPP Rev:C 11.10.18 as per NCR 11-906 DD verf:EC

Rev:D 112.04.16 AS PER ECN 12-542 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C34A		Purchased	No			230	Each	22.0000	1 ,	12	**************************************		1
BOLT									-7		*	10	448
				Location		Loc Qty	Lo	c Code	(e e	22)	2/10	/u
				ST353		22					_	7	
				116	075	4							
				117	514	18							,
AN3C36A		Purchased	No			230	Each	163.0000	444	A A A		Elast	42
BOLT											8 .		
				Location		Loc Oty	<u>Lo</u>	c Code	4	9	ジ	2/10/	10
				FG		24						•	
					261	4							
					204	20							
				ST353		139							
					590	0							
					083	1						•	
3					324	50							
					689 204	50 67							
					491 444	14							
				159		4							

NCR: Y	es / No				WORK ORDER NON-O	CONF	ORN	MANCE / UP	DATE			•
										QA Closed:	Date:	•
Work Orde	er:				DISPOSITION	,		a []	AGAINST DE	PARTMENT		1
Part N	lo			<u>.</u>	Rework Scrap Use-as-is	 _T	ı	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N	No				Work Order Update]		Large Fab	Composite		Supplier	
Root					iption of work order update	Init			tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data						1						
Equip/Tooling												-
Operator		1									:	
Material												
Setup				ı							i	
Other												
Process												
Supplier												
Training												
Unapproved										<u> </u>		
						AULT (CATE	GORY		,		
Landi	ng Gear				General					1		¬
	Bendin	-			Bend	-	rain			Ovalized	_	Pressure/Forced
	Centre	Not Conce	ntric to	o/s	_BOM/Route	Ha	ardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	In	specti	on Incomplete		Part Incorre	ct	Weld
	Crushe	d/Crimped			Burrs	In	struct	ions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Шм	lainte	enance		Part Moved		
	Heat Tr	eat			Countersink	Шм	lislabe	led		Positioned V	Vrong	_
	Inspect	ion Strip ir	1 Tube		Cut Too Short	М	lisreac	i		Power Loss/	Surge	Other
	Ripples	in Bend			Drill Holes	01	ffset					
	Torque	Waves in	Extrusio	n $ extstyle ex$	Drawing		ut of (Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

September-21-12 9:50:28 AM

Work Order ID:	90624										
prent Item:	D350-636-015						Start	Date: 9/21/12	Requ	ired Date: 10/26/12	
arent Item Name:	Skidtube STD w/ Training Wearplates, L.	Н		. 1			Start	Qty: 1.00	Requ	iired Qty: 100 /	
AN3C37A A	Purchased	No			250	Each	147.0000	1 \$		to to to	ک
			Location		Loc Qty		Loc Code		,	- ()	
			ST324		50						
			1222	04	50				/		
<u> </u>			ST353		80						
			1224		50			1778	130		
P			1228	43	30				_	•	
No.			ST354	7.4	17				.	-	
			1170		11 2			-	_		
			1204		3			-			
			1215		1						
Canaca2a	Purchased	No		•	250	Each	87.0000	1	1 ~		51
BOLT								eren. Oile. News	⊅e" •µe/		———————————————————————————————————————
			Location		Loc Qty		Loc Code				
			FG		5						
			1211	03	5						
: : :			ST354		82						
1 2 4 4 5 5 5 5 5 5 5 5 5 5 5 5 5 5 5 5 5			1061		1						
111			1204 1222		1 50			1222	 /		
			1222		30			122	7_'		
D3492-1 Plug \	Manufactured	No			230	Each	29.0000	8 2 (12/10/10)
•			Location		Loc Qty		Loc Code	0 (سے	, ,	
			FP002		22						
			6953	1	8						
1.*			7444		2						
			7623		4						
•			8854 262		8				<u> </u>		
			FP-A 903		7				_		
			8309 ~\Q_{\cup}	OL I	7						
				36 to 14							

NCR: Y	es /	No				WORK ORDER NON-	CON	NFORM	MANCE / UP	DATE					•
											QA (Closed:	Da	ite:	•
Work Orde	er:					DISPOSITION	7		(1	AGAINST D	EPART	MENT			
Part N	No					Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing	R		Water Jet d. Eng. Coor. e/Packaging	口	Engineering Quality Other
NCR N	No					Work Order Update]		Large Fab	Composite			Supplier		
Root				Ī	Descri	ption of work order update		nitial	Ad	ction	Sig	gn &			
Cause		Date	Step	Qty	,	or Non-conformance	Ch	ief Eng	Desc	cription		ate	Verification	n	QC Inspector
Doc/Data									<u>.</u>					İ	
Equip/Tooling	Ш				İ										
Operator	Ш														
Material	Ш														
Setup					ļ.										
Other									:						
Process	Щ												 		
Supplier	Ш														
Training	Ш														
Unapproved			<u> </u>	1	1		<u> </u>		2007						i <u></u>
117							AUL	T CATE	GORY						
Landi					Г-	General Bend	_	Grain		Г	Oval	:d			Pressure/Forced
	⊢	ending	-+ Camaa		~ 	BOM/Route	-	Hardwa		<i>"</i> }-			tolerance	\vdash	Temperature/Cure
	\vdash	entre No racks	ot Conce	ntric to	^{0/3} -	Broken/Damaged	-	4	ire ion Incomplete	-	→ .	Incorre			Weld
	⊢		Crimped.		-	Burrs	\vdash	1 `	tions Incomplete	/Uncloar		Lost/Mi		\vdash	Wrong Stock Pulled
	_	usneu/ uffs	crimpeu.	•	-	Contamination	-	Mainte		Joniclear	_	Moved	122111B		Wrong Stock Pulled
	—-	uns eat Trea	.+		-	Countersink	-	Mislabe		-		tioned V	Mrong		
	-		n Strip in	Tube	-	Cut Too Short	-	Misrea		-		er Loss/	-		Other
	$\boldsymbol{\vdash}$	ispection		TUDE	-	Drill Holes	\vdash	Offset	u	L		CI LUSS/	Juige	L	Other
	⊢	• •	aves in 8	extrusio	,	Drawing	-	4	Calibration						
	— '`	. 4			· · L] - · - · · · · · · · · · · · ·	L	1							

Out of Sequence

Outside Dimensions

Date: __

DQA:

Turning Sequence
Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print
September-21-12 9:50:28 AM

Work Order ID: Parent Item:	90624 D350-636-015							Start I	Date: 9/21/12	Requi	red Date: 10/26/12
Parent Item Name:	Skidtube STD w/ 7	raining Wearplates, I	LH					Start	Qty: 1.00	and the second of the second	ired Qty: 1.00
D3492-3 Plug		Manufactured	No			230	Each	123.0000	8	8 Ø	12/10/10
				Locatio	<u>n</u>	Loc Qty		Loc Code	_		/ '
				FP-A		123					
					81967	5					
					83099	3					
					83529	46					
					85461	9					
					86865	60					
D3873-1 Bushing		Manufactured	No			230	Each	69.0000	7 7	⁷ @	12/10/1
				Locatio	<u>n</u>	Loc Qty		Loc Code	,		,
				ST057		6					
					79561	6					
				ST067	90492~	63					
				51007	64760	1					
					68247	4					
					73829	19					
					73830	2			-		
					76791	17					*
					79560	20					
D4154-041 Wearplate Assembly		Manufactured	No	!	90298/	230	Each	0.0000	1	100	12/10/10
D4170-1 Bushing		Manufactured	No		, -	230	Each	39.0000	4	4	BE 12/0/02
				Locatio	<u>n</u>	Loc Qty		Loc Code			, ,
				LG		30			. 1		
					82222	30			4		
				LG001		9					
				LC001	71844	5			-		
					82043	4					

											DQA:	Date	
NCR:	Yes	/ No				WORK ORDER NON-O	O	NFORN	/ANCE / UPD	PATE	QA Closed:	Date	
						DISPOSITION				AGAINST DE			•
Work Orde Part N	-				•	Rework Scrap]		Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	-					Use-as-is Work Order Update		Therm	noforming Large Fab	Finishing Composite	-i	re/Packaging Supplier	Other
Root				,	Descri	ption of work order update		nitial	Acti	on	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
		-	.			F	AUL	T CATE	GORY				
Landi	ng G	iear				General	700	. CATE	301.				
		Bending Centre No Cracks Crushed/			o/s	Bend BOM/Route Broken/Damaged Burrs		1 `	re on Incomplete ions Incomplete/U	Inclear	Ovalized Over/Under Part Incorre Part Lost/M	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
		Cuffs Heat Trea	it			Contamination Countersink		Mainte Mislabe			Part Moved Positioned		_
	┉┥	Inspectio Ripples in	•	Tube		Cut Too Short Drill Holes		Misread Offset	ł		Power Loss,	/Surge	Other

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

September-21-12 9:50:29 AM

Work Order ID:	90624							
Parent Item:	D350-636-015					Star	t Date: 9/21/12	Required Date: 10/26/12
Parent Item Name:	Skidtube STD w/ Training Wearplates, I	LH				Sta	rt Qty: 1.00	Required Qty: 1.00
D4171-1 Bushing	Manufactured	No		230	Each	3.0000	1	@ 12/10/10
			Location	Loc Qty		Loc Code		, , ,
			ST104	3				
			82385	3				
MS21043-3 Nut	Purchased	No		230	Each	762.0000	5 45 5	12/10/10
			Location	Loc Qty		Loc Code		, , , , , , , , , , , , , , , , , , ,
			FG	72				<u>•</u>
			103691	72				
	$\sim 1 \sim 1$		ST301	190				
	* *		118077	2				
			118614	7				<u> </u>
			118686	30				_
			119758 121255	20 20			-	_
			121708					
			ST315	500				_
			122993	500				_
NAS1149C0363R Washer	Purchased	No			Each	4,787.0000	4 7 9 1	12/10/10
			Location	Loc Qty		Loc Code	9 7 6	1-
	, ,		297	2000				
			122441	2000				
	-XX-		ST297	2787				
			114742					
	, v		122063	200				_

											DQA:	Date	
NCR:	Yes	/ No				WORK ORDER NON-C	OI	NFORM	∕IANCE / UP	DATE	QA Closed:	 Date	•
Mort Ord		**				DISPOSITION				AGAINST DE			
Work Orde Part N	- - No.					Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	Ĩ				Descri	ption of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved					•	F	AUL	.T CATE	GORY				
Landi	ng G	ear		•		General							
·		Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in	n Strip in n Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	ion Incomplete tions Incomplete/ enance eled d	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Torque V	Vaves in E	xtrusio	n	Drawing	1	JOut of (Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

September-21-12 9:50:29 AM

Work Order ID:	90624							a	0/01/10	_	10/06/12
Parent Item:	D350-636-015								Date: 9/21/12	_	uired Date: 10/26/12
Parent Item Name:	Skidtube STD w/	Training Wearplates	s, LH					Start	Qty: 1.00	Rec	uired Qty: 1.00
NAS1149D0863J WASHER		Purchased	No			250	Each	159.0000	2	2 -	
>				Locatio	<u>n</u>	Loc Oty		Loc Code			
				ST298		159					
					118078	28					
					119307	1					
					120308	30			12030	18	
					121556	100					
NAS1515H3L WASHER		Purchased	No			230	Each	227.0000	4 _ -	60	12/10/10
C				Locatio	<u>n</u>	Loc Qty		Loc Code	·	_	, ,
				FG		40					
					102472	40					
				ST277		187					
					118686	3					
					120360	11				_	
					121556	45					
					122151	128					
NAS1611-010 O-RING		Purchased	No			230	Each	160.0000	* <i>8</i>	8	12/10/10
	-			Locatio	<u>n</u>	Loc Oty		Loc Code			
				FP001		160					
					110915	14					
					117460	8					
	V				118077	1					
					118612	3					
					119438	47					
					121259	2					
					121584	2					
					121723	7			-		
					122151	76					

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	QA Closed:	Date:	•				
									-	QA Closed:	Date.	
Work Orde	ar.				DISPOSITION AGAINST					PARTMENT,	PROCESS	
Work Orac					Rework Skid-tube Crosstube						Water Jet	Engineering
Part N	No.				Scrap	1	M	1achining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	Th	erm	oforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	No				Work Order Update	Work Order Update Large Fab Composite						
Root				Descri	ption of work order update	Initia	П	Actio	n	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng	Descrip	tion	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material							l					
Setup												
Other												
Process												
Supplier												
Training						1						
Unapproved												
					F.	AULT CA	TEG	ORY				
Landi	ng Gear				General					_		_
	Bending				Bend	Gra	Grain			Ovalized		Pressure/Forced
	Centre 1	lot Conce	ntric to (o/s	BOM/Route	Hard	dwar	e		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Insp	ectic	n Incomplete		Part Incorre	ct	Weld
	Crushed	/Crimped			Burrs	Insti	ructio	ons Incomplete/Un	clear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mai	inter	nance		Part Moved		
	Heat Tre	eat			Countersink	Mislabeled				Positioned V	Vrong	
	Inspecti	on Strip in	Tube		Cut Too Short	Misr	read			Power Loss/	Surge	Other
	Ripples	in Bend			Drill Holes	Offs	et			-		

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

September-21-12 9:50:29 AM

Work Order ID:	90624											
Parent Item:	D350-636-015								Start I	Date: 9/21/12	Requi	red Date: 10/26/12
Parent Item Name:	Skidtube STD w/ 7	Γraining Wearplates, I						Start	Qty: 1.00	Required Qty: 1.00		
NAS1611-013 Ö-RING	,	Purchased	No			230		Each	228.0000	8 8		12/10/1
8				Location	<u>n</u>	Loc (<u> </u>		Loc Code			
				FP001			228					
					116582		5					
					117291		2					
					117887		53					
					119623		36					
					121825		18					
					121826		14					
					122993		100					
2744		Manufactured	No			110		Each	36.0000	1	1	B1-12/09/27
ар												D1-140 9~ 1
				Location	<u>n</u>	Loc (<u>)ty</u>		Loc Code			
				LG002			36					
					62715		1					
					85506		35			/·		
2600-3-BENT xtrusion Bent		Manufactured	No			110		Each	28.0000	1	13	12/09/27
-				Location	<u>n</u>	Loc C	<u> Oty</u>		Loc Code			-
				LG			28					
					66875		7					
					73253		i					
					75021		1					
					75022		1					
					75023		i			·		
					81330		4					
					83305		1					
					88712		5					
				<	90251		7					
-				****								

NCR: Ye	es / No				WORK ORDER NON-	COI	NFORI\	MANCE / UPI	DATE						
					 					QA Closed:	Date	· ·			
Work Order					DISPOSITION	AGAINST DEPARTMENT/PROCESS									
Part No	D				Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other				
Root				Descri	otion of work order update		Initial	Act	ion	Sign &					
Cause	Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector			
Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved					F	AUI	LT CATEC	GORY							
Landing	g Gear				General		-		_	·	_				
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Wayes in Extrusion			Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/U nance led	Jnclear	Ovalized Over/Under Part Incorre Part Lost/N Part Moved Positioned Power Loss	ect lissing l Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other				

Out of Sequence

Outside Dimensions

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish Folio September-21-12 9:50:30 AM

Work Order ID: Parent Item: Parent Item Name:	90624 D350-636-015 Skidtube STD w/ T	Training Wearplates, I	LH					Date: 9/21/12 Qty: 1.00		Required Date: 10/26/12 Required Qty: 1.00		
D2743		Manufactured	No			160	Each	267.0000	8	8	as alalas	
Crossbolt Spacer									····	······································	B&12[10]02	
				Location		Loc Qty		Loc Code				
in .				LG		193						
<u>.</u>					81965	23						
					83262	2			-0			
					85459 88504 े	46			8			
					88304 %	122						
•				LG001	67766	74						
					68251	3						
					73403	64						
	ž				74445	1					•	
3					79517	2						
2739		Manufactured	No			160	Each	5.0000	1 .	-	20/20/	
50 I Beam											12/10/01	
⊀ .				Location	90509	Loc Qty		Loc Code			, ,	
				LG	90201	5						
					72155	1						
					81508	1						
					85487	1						
**					86615	1						
4. Ž					87734	ì						
)3490-3 		Manufactured	No			160	Each	50.0000	4	4	BE12/0/02	
ross Bolt Spacer	•										<u> </u>	
				Location		Loc Oty		Loc Code			•	
÷				LG001		50					•	
					85420	10						
					86980	40						
į.												

											DQA:	Date						
NCR: Y	es .	/ No				WORK ORDER NON-	NFORM		QA Closed:	Date								
,		<u> </u>				DISPOSITION		AGAINST DEPARTMENT/PROCESS										
Work Orde	er: _					DISPOSITION	<u>,</u> [AUA			Water Jet						
Part N NCR N						Rework Scrap Use-as-is Work Order Update		f Therm	Machining Sma	stube II Fab shing	Pro Rec/Stor	Engineering Quality Other						
NCKK	' '				·	Work order opdate	_		comp	,osite	1	Supplier						
Root					Descri	ption of work order update	П	Initial	Action		Sign &							
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector					
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved																		
							AUL	LT CATE	GORY	· · · · · · · · · · · · · · · · · · ·								
Landir		Bending Centre No Cracks Crushed/ Cuffs Heat Trea nspectio	n Strip in		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misread	on Incomplete ions Incomplete/Unclear nance led		Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other					
. !	Ripples in Bend					Drill Holes	1	Offset										

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing Finish

September-21-12 9:50:30 AM

90624 Work Order ID: Parent Item: D350-636-015 **Start Date: 9/21/12** Required Date: 10/26/12 Skidtube STD w/ Training Wearplates, LH Start Qty: 1.00 Required Qty: 1.00 Parent Item Name: D3490-1 Manufactured No 160 Each 113.0000 Cross Bolt Spacer Location Loc Qty Loc Code LG 104 81976 2 86979 40 88617 62 LG001 62450 74875 4 77042 3 230 2,785.0000 ALS4-1032-225 No Each Purchased 12/10/10 Insert Loc Code Loc Oty Location FP-B 1346 122290 1346 ST281 1416 108696 146 110768 62 55 118386 68 118966 85 121269 122827 1000 ST282 23



10

13

120410

120451

											D	QA:	Date	e:	• •
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORN	/ANCE / UP	DATE				_	,
											QA Clos	sed:	Dat	e:	*
Work Ord	or.					DISPOSITION				AGAINST D	EPARTMI	ENT/	PROCESS		
Work Ord	٠, .					Rework	7	İ	Skid-tube	Crosstube	7		Water Jet	\neg	Engineering
Part 1	No.					Scrap	1	ľ	Machining	Small Fab]	Prod	l. Eng. Coor.		Quality
	-					Use-as-is			noforming	Finishing	Rec/	'Store	e/Packaging	_	Other
NCR I	No.	 				Work Order Update	J		Large Fab	Composite			Supplier		
Root					Descri	ption of work order update		Initial	Ac	tion	Sign	&			
Cause		Date	Step	Qty	(or Non-conformance	Cr	nief Eng	Desc	ription	Date	2	Verification	1	QC Inspector
Doc/Data	Ш											ļ			
Equip/Tooling	Щ														
Operator	Ш														
Material	Ш								:						
Setup	Ш						ŀ					1			
Other	Ш											ļ		1	
Process	Н														
Supplier	Ш						ŀ								
Training	Ш														
Unapproved			<u> </u>								<u> </u>				
		· · · · · · · · · · · · · · · · · · ·					AUI	LT CATE	GORY				······································		
Landi		l .				General	_	7		Г	٦		ſ		i
		Bending	_		_	Bend	\vdash	Grain		-	Ovalized				Pressure/Forced
	\vdash	Centre N	ot Concei	ntric to	O/S	BOM/Route	\vdash	Hardwa		<u> </u>			tolerance		Temperature/Cure
	\vdash	Cracks			<u> </u>	Broken/Damaged	<u> </u>	4 '	on Incomplete	, <u> </u>	Part Inc		.	\vdash	Weld
	\vdash	Crushed/	Crimped.		-	Burrs	\vdash	┪	ions Incomplete/	'Unclear	Part Los		ssing		Wrong Stock Pulled
	Cuffs					Contamination		Mainte		<u> </u>	Part Mo				
	Heat Treat					Countersink	-	Mislabe		<u> </u>	Position				l
	-	Inspectio	•	Tube	<u> </u>	Cut Too Short	_	Misread	d	L	Power t	_oss/S	Surge		Other
I	1	Ripples ir	n Bend		1	Drill Holes	1	Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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September-21-12 9:50:30 AM

Work Order ID:	90624										
Parent Item:	D350-636-015							Start 1	Date: 9/21/12	Require	d Date: 10/26/12
Parent Item Name:	Skidtube STD w/ T	raining Wearplates, I	LH					Start	Qty: 1.00	Requir	ed Qty: 1.00
AN8C35A BOLT		Purchased	No			230	Each	30.0000	1	1	12/10/10
				Locatio	<u>n</u>	Loc Qty		Loc Code		-	, ,
•				FG		5					
1. The second se					121275	5					
				FP002		24					
					115960	1					
					121275	23					
				ST346		1					
					114442	0					
					115188 115960	0					
D3488-041		N C . 1	No		113900	230	Each	23.0000	1		. /
Blade Fitting Assembly	.LH »	Manufactured	NO			230	Laci	23.0000		' <i>O</i>	12/10/10
place Fitting / issembly	, 111			Locatio	.	Loc Qty		Loc Code			
					ш			<u>Loc Code</u>			
				FP001	85807	3					
,				CD002	63607						
*				FP002	83407	20 3					
					85733	5					
					88255	12					
AN6C44A BOLT	-	Purchased	No			230	Each	116.0000	4 4	(H)	12/10/10
· ·				Locatio	<u>n</u>	Loc Qty		Loc Code			
				FG		2					
					103964	2					
				ST340		44					
					122491	44					
				ST341	_	50					
					122843	50					
				ST343		20					
					121013	11					
and the state of					122204	9					

											DQA:	Date	·
NCR:	Yes	/ No				WORK ORDER NON-O	O	NFORM	/ANCE / UPI	DATE	QA Closed	: Date	
						DISPOSITION				AGAINST DE			
Work Ord	er: ˌ					D13F03111014	.			AGAINST DE		/1 NOCE33	
Part I	No.					Rework Scrap Use-as-is		ſ	Skid-tube Machining noforming	Crosstube Small Fab Finishing	-1	Water Jet od. Eng. Coor. re/Packaging	Engineering Quality Other
NCR I	No.	- · · · · ·				Work Order Update]		Large Fab	Composite]	Supplier	
Root					Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup													
Other													
Process													
Supplier							1				ļ	1	
Training													
Unapproved													
						F	AUI	LT CATE	GORY				
Landi	ng (Gear				General			,		_		
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre N	ot Conce	ntric to (o/s	BOM/Route		Hardwa	re		Over/Unde	r tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part Incorre	ect	Weld
		Crushed/	Crimped			Burrs	Г	Instruct	ions Incomplete/I	Unclear	Part Lost/N	lissing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved	i	_
		Heat Trea	it			Countersink		Mislabe	·led		Positioned	Wrong	
		Inspectio	n Strip in	Tube		Cut Too Short	Г	Misread	ł		Power Loss	/Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

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Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

· Picklist Print

September-21-12 9:50:30 AM

Page 10

Work Order ID:	90624					
Parent Item:	D350-636-015			St	tart Date: 9/21/12	Required Date: 10/26/12
Parent Item Name:	Skidtube STD w/ Training Wearplat	es, LH		S	Start Qty: 1.00	Required Qty: 1.00
MS21083C8 NUT	Purchased	No	230	Each 53.0000	1	12/10/10
		Location	Loc Qty	Loc Code		
		318	29	8	حـــــــــــــد	
		1224	52 29	' '		
		FP002	1			
		1158	84 1	}		
		ST303	4			
		1158				*****
		1180				
		1193			<u></u>	
		1196				
		ST321 1221	19			
D3631-1 Washer ✓	Manufacture		230	Each 143.0000	8 _{\bar{8}}	OR 12/10/10
	San	Location	Loc Qty	Loc Code	•	
		FG	28			
		8187			•	
		8358				
		FP-A	100			
		8927	7 100			
		ST072	15			
		6806			·	
		7554				<u> </u>
AN960C10L washer	NAS1149C0332R Purchased	No	230	Each 21.0000	4	12/10/10
		Location	Loc Qty	Loc Code		1 '
		ST	21			
		1075	34 21			<u></u>
		10	3248/			

											DQA:	Date:	
NCR: Y	⁄es	/ No				WORK ORDER NON-C	O	NFOR	√ANCE / UP	PDATE	QA Closed:	Date:	
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	ا No					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-}	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	1	nitial	Ac	ction	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved								T.CATE	CODY				
Landi			·				AUL	T CATE	GORY				-
Landi	Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion					General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	ion Incomplete tions Incomplete, enance eled	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned \ Power Loss	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

September-21-12 9:50:31 AM

Work Order ID: Parent Item: Parent Item Name:	90624 D350-636-015 Skidtube STD w/	Training Wearplates, I	LH					Date: 9/21/12 Qty: 1.00	-	ed Date: 10/26/12 red Qty: 1.00
D2745 Bushing	S	Manufactured	No		230	Each	142.0000	88	8	12/10/10
				<u>Location</u>	Loc Qty		Loc Code			, ,
				FP	138					
				79518	<i>پ</i> ے 6	,ege				•
				85416	> 12					
				86870	40					
				87527	40					
				89303	40					
				FP001	4					•
•.				69529	1					
•				76142						
NAS1149C0832R WASHER		Purchased	No	83260	230	Each	419.0000	1		12/10/10
				Location	Loc Oty		Loc Code			' '
				296	200					
		***		122441	200					
				ST297	219					
e e e e e e e e e e e e e e e e e e e				114915	219					

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE			•
								,			QA Closed:	Date:	• · · · · · · · · · · · · · · · · · · ·
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
1	· · ·			-		Rework	٦.		Skid-tube	Crosstube]	Water Jet	Engineering
Part	No.					Scrap	1	ſ	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is			noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR	No.					Work Order Update	ال		Large Fab	Composite		Supplier	
Root			<u> </u>		Descri	ption of work order update	Т	Initial	Δς	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	1	nief Eng		ription	Date	Verification	QC Inspector
Doc/Data			3.57	~-,			1						
Equip/Tooling													
Operator				,								<u> </u>	
Material													
Setup			1										
Other												1	1
Process													
Supplier													
Training													
Unapproved													
							AUI	T CATE	GORY				
Land	ng (Gear				General	_	,			_		3
		Bending				Bend	L	Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route	<u> </u>	Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		4	ion Incomplete		Part Incorre	ct	Weld
	L	Crushed/	Crimped.			Burrs	_	Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		
		Heat Trea	it			Countersink		Mislabe	:led		Positioned \	Wrong	-
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	Ł		Power Loss,	'Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

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September-21-12 9:50:31 AM

Vork Order ID:	90624									
arent Item:	D350-636-015						Start D	ate: 9/21/12	Requi	red Date: 10/26/12
årent Item Name	Skidtube STD w	/ Training Wearplates	s, LH				Start (Qty: 1.00	Requ	ired Qty: 1.00
N3C6A OLT	-	Purchased	No		230	Each	1,139.0000	4 4	199	T2/10/10
÷			Loca	<u>ation</u>	Loc Qty		Loc Code		_	1 (
			FG	,	10					
				122416	10					
			FP00	01	1					
				111982	1					
			ST3:		1128					
			515.	111982	2			-	 ,	
				116419	23					
				116549	2			-	 -	
				116704	12					
				117619	10					
				117688	1					
				117872	5					
				118422	13					
				119449	21					
				120423	3					
				120693	42					
				121682	4					
				122416	490					
4	,			122599	500			-		
1 S21043-6 ÎUT	4	Purchased	No		230	Each	466.0000	4 4	(DP)	12/10/10
			Loca	ation	Loc Qty		Loc Code			, ,
			FG		20					
				103693	20				_	
			ST3		446					
			313	117887	2					
				120308	444					

NCR: Y	es / No				WORK ORDER NON-	CON	FORN	/IANCE / UP	DATE			
										QA Closed:	Date:	
Work Orde	r·				DISPOSITION	ı			AGAINST D	DEPARTMENT,	PROCESS	
WOIR Olde	1.				Rework	٦١		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	0.				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	***************************************				Use-as-is	1	Therm	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	0				Work Order Update]		Large Fab	Composite		Supplier	
Root	Τ			Descri	ption of work order update	l Ir	nitial	Δα	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	ı	ef Eng		ription	Date	Verification	QC Inspector
Doc/Data	Jule	1				1						
Equip/Tooling		ŀ										
Operator		ŀ		-		1						
Material		ł										
Setup		1										
Other												
Process												
Supplier		1										
Training [
Unapproved						<u> </u>						
					F	AULT	CATE	GORY				
Landir	ng Gear			_	General			,	_			 1
]	Bending				Bend		Grain		Ļ	Ovalized	_	Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks Broken/Dama				Broken/Damaged	\vdash	•	on Incomplete	1	Part Incorre		Weld
	Crushed/Crimped				Burrs	-		ions Incomplete/	'Unclear	Part Lost/M	ssing	Wrong Stock Pulled
	Cuffs				Contamination	\vdash	Mainte			Part Moved		
1	Heat Treat Countersink				-	\vdash	Mislabe		1	Positioned V	_	- 1
1	Inspectio	-	Tube		Cut Too Short	\vdash	Misreac	i	Ĺ	Power Loss/	Surge	Other
	Ripples ir			<u> </u>	Drill Holes	\vdash	Offset					
İ	Torque Waves in Extrusion Drawing						Out of C	Calibration				

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

September-21-12	0:50:31 AM											1 480 10
Work Order ID: Parent Item:	90624 D350-636-015							Start	Date: 9/21/12	Reau	ired Date: 10	0/26/12
Parent Item Name:		Training Wearplates,	LH						t Qty: 1.00		uired Qty: 1.0	
D3493-1 Washer		Manufactured	No			250	Each	37.0000	2	2		Ties of the same o
0				Locatio	<u>n</u>	Loc Oty		Loc Code				- 1
				ST050		37				_		
					77573	1				_		
,					82023	2						
					83097	34			8309	_/	1	Λ
MS21083C8		Purchased	No			250	Each	53.0000	2	2 -	(K)	
				Locatio	<u>n</u>	Loc Qty		Loc Code				
				318		29						
					122452	29			12248	2		
				FP002		1			, , , , , , , , , , , , , , , , , , , ,			
					115884	1				_		
				ST303		4						
					115884	0				_		
					118077	1				_		
					119309	2				_		
					119638	1				_		A
				ST321		19				_		
1					122141	19				_	//	
AN8C21A BOLT		Purchased	No			250	Each	41.0000	2	2	1/2/12] ** [[] [] [] [] [] [] [] [] [] [] [] [] []
				Locatio	<u>n</u>	Loc Qty		Loc Code				/
				ST341		25						
,					122519	25			12251)		
				ST343		16				_		
					118758	1			W- W- W- W- W- W- W- W- W- W- W- W- W- W	_		
					122204	15				_		

											DQA:	Date:	• • •
NCR: Y	⁄es	/ No				WORK ORDER NON-O	COI	NFORM	/ANCE / UP	DATE	QA Closed:	Date	•
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	· ·
	۰ No.		4490			Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause	ļ	Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved						F	AUI	T CATE	GORY				
Landi	ng G	iear				General	701	CATE	3011				
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion					Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	ion Incomplete ions Incomplete/ enance eled	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
1 1		Torque W	raves in E	:xtrusioi	1	Drawing	1	Jour of 6	Jaiipration				

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

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September-21-12 9:50:31 AM

Work Order ID:

90624

Parent Item:

D350-636-015

Parent Item Name:

Skidtube STD w/ Training Wearplates, LH

Start Date: 9/21/12

Required Date: 10/26/12

Required Qty: 1.90

Start Qty: 1.00

,/D2741 Blade, 350 Skidtube Manufactured

250

Each

26.0000

Location Loc Qty Loc Code 2 FG 2 85480 ST -10 ST466 34 71856 85480 23

•									DQA:	Date:	e , ,
NCR: Y	'es / No				WORK ORDER NON-O	CONFO	RMANCE / UI	PDATE	QA Closed:	Date:	•
Work Orde	ar:				DISPOSITION			AGAINST DE			
Part N	No				Rework Scrap Use-as-is Work Order Update	Th	Skid-tube Machining ermoforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	iption of work order update	Initia	Α	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng Des	cription	Date	Verification	QC inspector
Doc/Data Equip/Tooling											
Operator						İ				:	
Material											
Setup											
Other		1									
Process											
Supplier Training						1					
Unapproved											
Gliappioved		<u> </u>	i		<u> </u>	AULT CA	 TEGORY		<u> </u>	1	
Landii	ng Gear			** 120	General					······································	
	Bending				Bend	Gra	n		Ovalized		Pressure/Forced
:	Centre Not Concentric to O/S				BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Insp	ection Incomplete		Part Incorre	ct	Weld
	Crushed/Crimped				Burrs	Insti	uctions Incomplete	e/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	\blacksquare	ntenance		Part Moved	-	_
	Heat Trea	at			Countersink	Misl	abeled		Positioned \	W rong	_
	Inspectio	n Strip in	Tube		Cut Too Short	Misr	ead		Power Loss,	/Surge	Other
	Ripples in	Bend			Drill Holes	Offs	et		-		
	Torque W	aves in E	xtrusio	n [Drawing	Out	of Calibration				

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

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-041	QTY -042	-043	-044	PART NUMBER	DESCRIPTION
Х	l		1	D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
Ľ.		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			Х	D4168-044	350 SKIDTUBE ASSEMBLY, RH
	 	ļ	L		
_ 1_	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1_1_	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
- 8	8	8	. 8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3873-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	_ 4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C6A	BOLT
1	1	_1_	1	AN3C34A	BOLT
4	4	4	4	AN3C36A	BOLT
4	4	4	4	AN6C44A	BOLT
11	1	1	1	AN8C35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
- 4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
1	1	1	1	AN960C816L	WASHER (OR NAS1149CO832R)
5	5	5	5	MS21043-3	NUT
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	_4	4	4	NAS1515H3L	WASHER

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RELEASE 1 2010 -09- 15

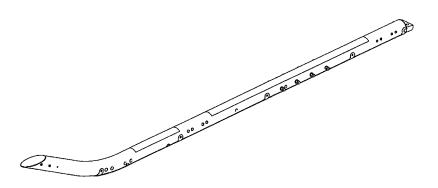
_ A	NEW IS	SUE	SC	10.08.09	
REV.			DESCRIPTION BY	DATE	
DESIGN		sc	DART AEROSPACE USA, INC.		
DRAWN '		SC	PORT HADLOCK, WA		
CHECKED		0	DRAWING NO.	REV. A	
MFG. APPR.		W	D4168	SHEET 1 OF 11	
APPROVED		WA	TITLE	SCALE	
DE APPR.		#-	☐350 SKIDTUBE ASSEMBL`	Y NTS	
DATE 10.08.09			COPYRIGHT @ 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PROVIET AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONFIDENT THAT IS IS		

MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).

MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
FINISH:

CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: N/A
IDENTIFICATION: N/A
WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
WELD PER DART QSI 004
FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM VIELD TENSILE STRENGTH = 35 KSI
MINIMUM VIELD TENSILE STRENGTH = 38 KSI
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL

90624



D4168-041 350 SKIDTUBE ASSEMBLY, LH

D4168-042 350 SKIDTUBE ASSEMBLY, RH

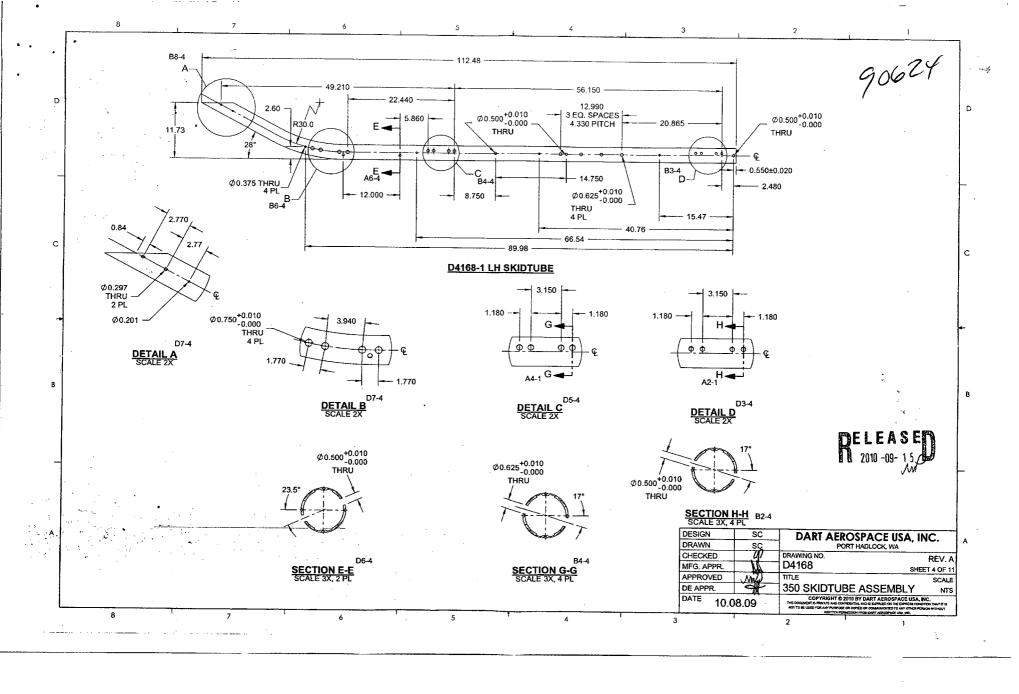
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DE APPR.	-#-	350 SKIDTUBE ASSEMBLY	NTS	
DATE 10.0	08.09	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. DEI DOCLANDE REVOLTE AUX CONSENSIONAL AND IS BUPLED ON THE DWINESS CONCENSION THAT IT IS NOT TO SECURE FOR ANY PLACEMENT OF COMPANY OF COMPANY OF THAT IS NOT THE WINDOW.		

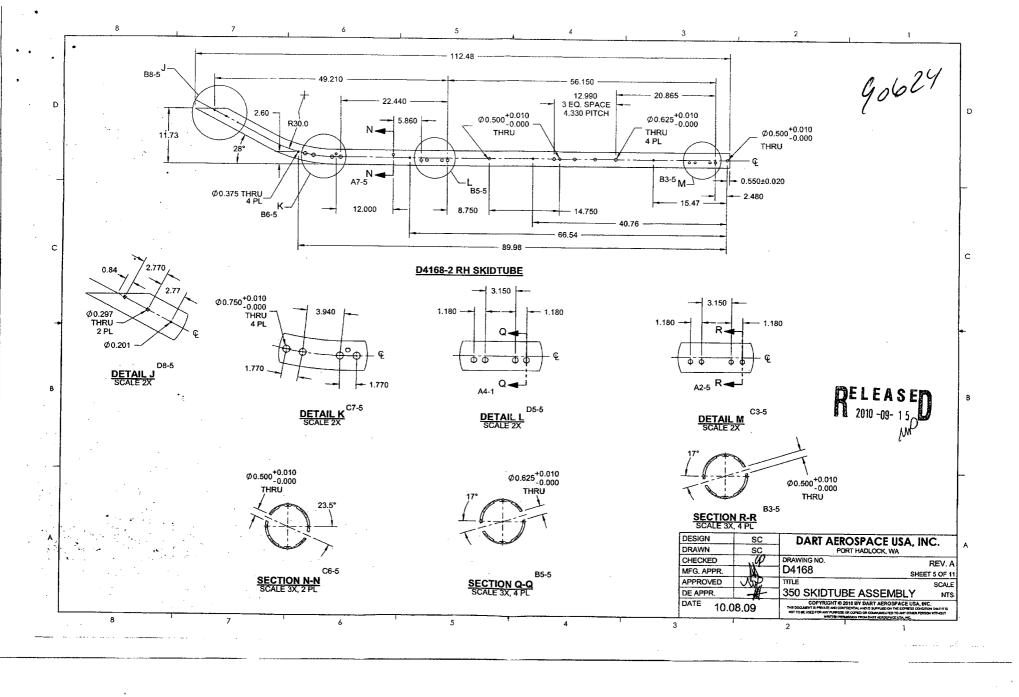
D4168-043 350 SKIDTUBE ASSEMBLY, LH

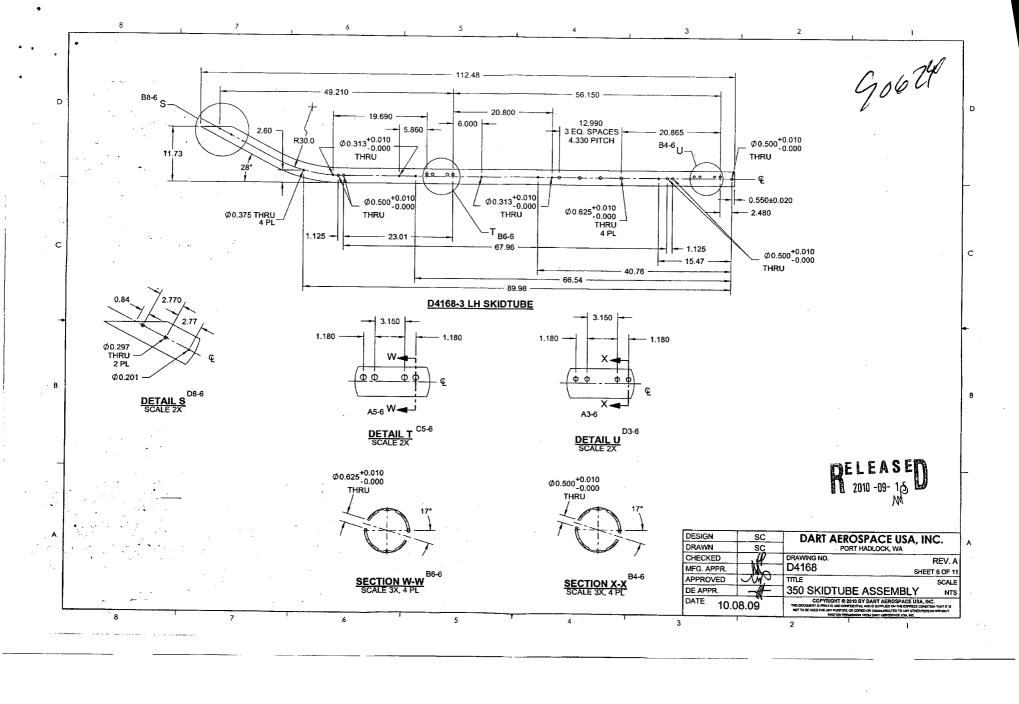
D4168-044 350 SKIDTUBE ASSEMBLY, RH

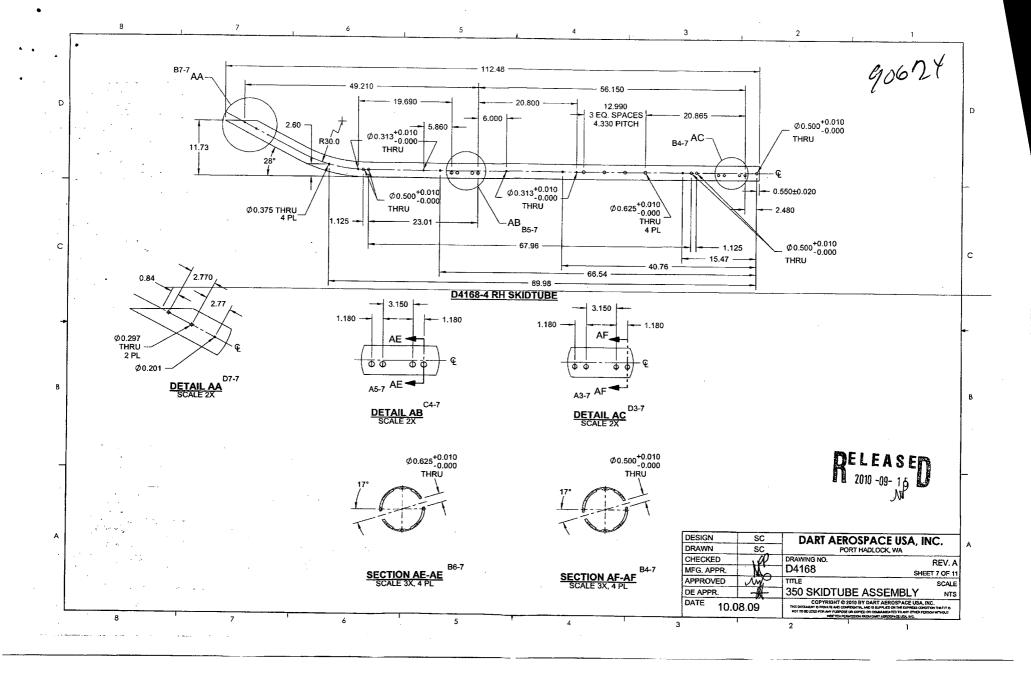
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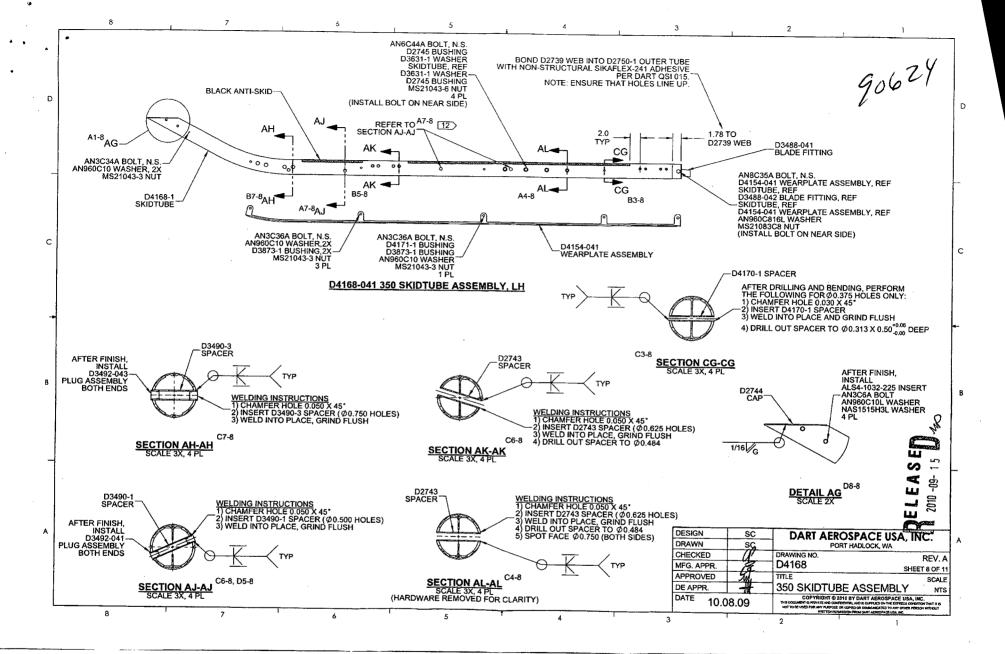
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DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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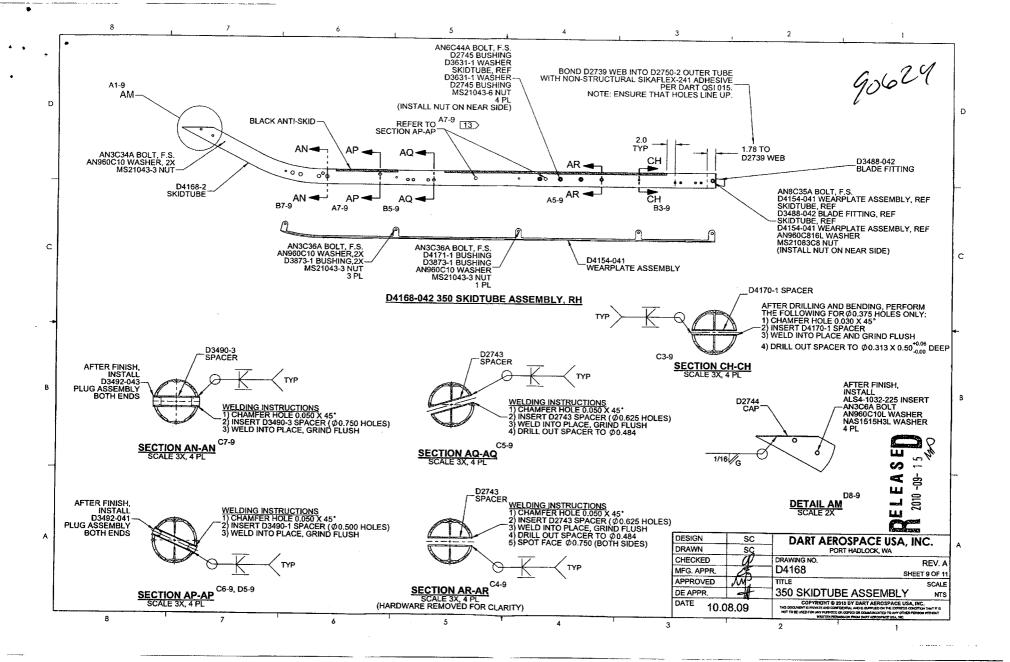


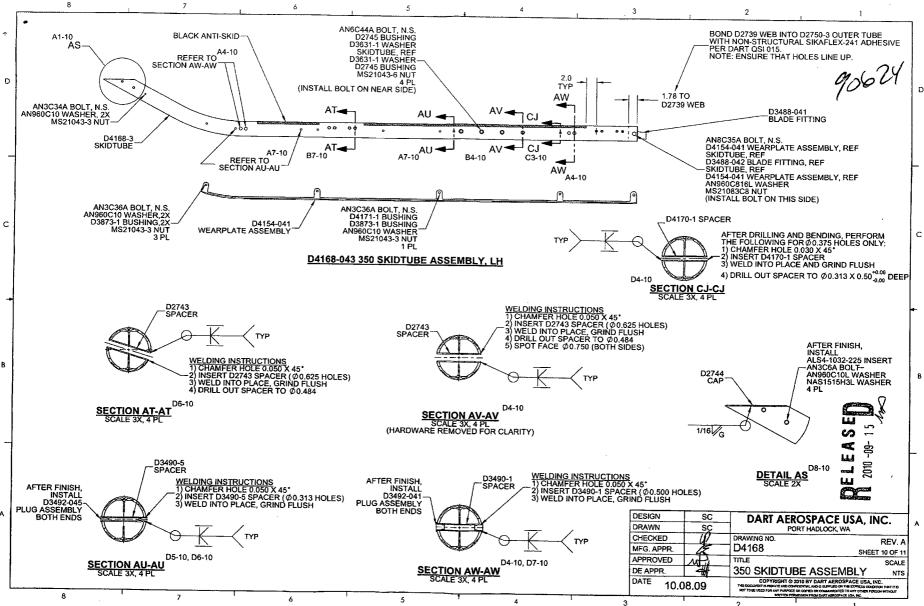


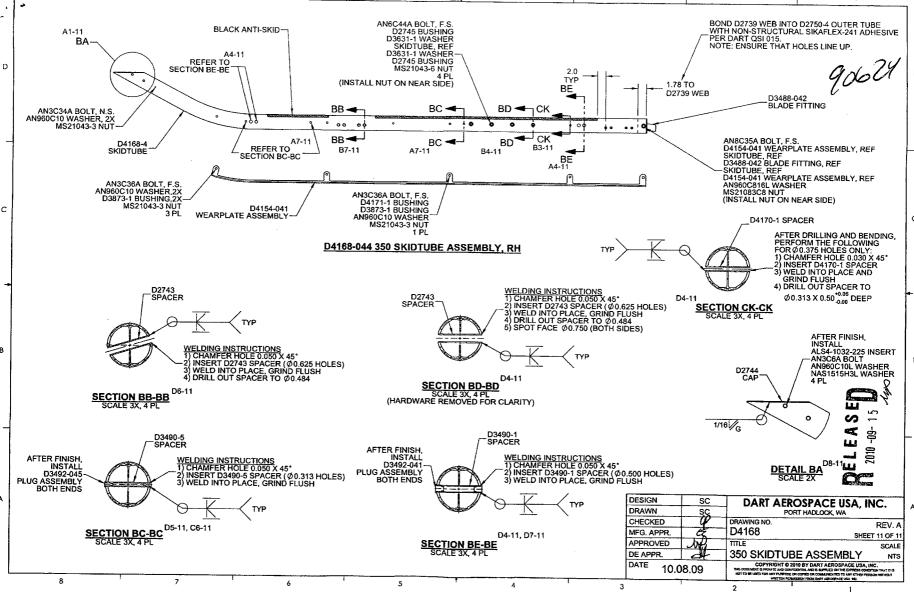












NO. 300

AWS D17.1.2001 QUALIFICATION TEST RECORD

Name:	Barday Elliott	
Job #:	87941	
Part #:	1350-636-011	
Description	n: Seid	
Welding P	rocess: Tig[-/ Mig[]	
Base mater		
Current: 2	AC[J DC[]	

TEST REQUIREMENTS AND RESULTS

Visual:	pass[] fail[]
Incomplete Penetration:	pass[/] fail[]
Incomplete Fusion:	pass[// fail[]
Cracks:	pass[/] fail[]
Overlap (cold lap)	pass['] fail[]
Undercut:	pass[] fail[]
Pin holes:	pass[/ fail[]
Porosity (surface):	pass[/ fail[]
Coloration:	pass[/ fail[]
Burn through:	pass[fail[]

Qualifier Date of Test Coupon 12.07.26

Welder Bareloy Elliot Date of Test Coupon 12-07-24

The above named individual is qualified in accordance with AWS D17.1.2001 to weld